

Date: Thursday, 04/12/2008 10:33:34 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE
 Job Number : 05063
 Estimate Number : 13641
 P.O. Number :
 This Issue : 04/12/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 43911
 Part Number : D37081
 Drawing Number : D3708 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 11/12/2008 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : MF 08-12-04
 Comment : Est Rev:A 08-10-31 new issue DD verified by:EC

Additional Product

Job Number:



PRELIMINARY ISSUE
PROTOTYPE
 FOR ENGINEERING USE ONLY
 REV-A
 09.01.16
 08-10-31 new issue DD verified by:EC

Seq. #: Machine Or Operation: Description :

1.0 M6061T6A750W0625 angle .750 x .750 x .625w



P.T.O.



Comment: Qty.: 1.4359 f(s)/Unit Total : 4.3076 f(s)
 angle .750 x .750 x .625w

m 107983

FF 08/12/15 3

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- cut to length as per dwg
 2- mark, cut notch and deburr as per dwg
 3- bend angle as per dwg D3708

PTC

FF 08/12/15 8

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-22 (3)
ENGINEERING APPROVED
 ALM
 9-1-06

09.01.16 (3)

(3)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 09-01-16

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 29


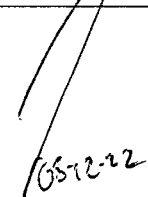
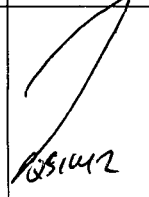
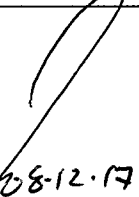
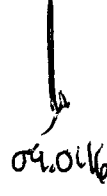

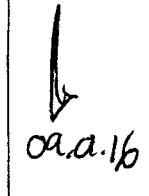

9/16/18

(3)

56

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3708-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 05/06/08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>05063</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-17	2.0	3 parts scrap. Made to spec to chg. dim 1.16" is 1.9", 15.35" is 14.7" R.C. did not make part to chg.		Scrap & replace Qty 3 M <u>107983</u> Return to verify work to the chg before giving it into inspection.	08/12/22 FF			
09-01-16	1.0	MATERIAL USED IS 6061T5 INSTEAD OF 6061T6.		ACCEPTABLE ON THE BASIS THAT DART-761-041 WAS TESTED WITH 6061-T5.	MKF 09/11/16			

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 10:33:34 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 05063

Part Number: D37081

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08 *[Signature]*

Job Completion



MF 09-01-16

POSITIVE RECALL
EFFECTIVE 09.06.16 AUTH U
RELEASED 7 DATE 09.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

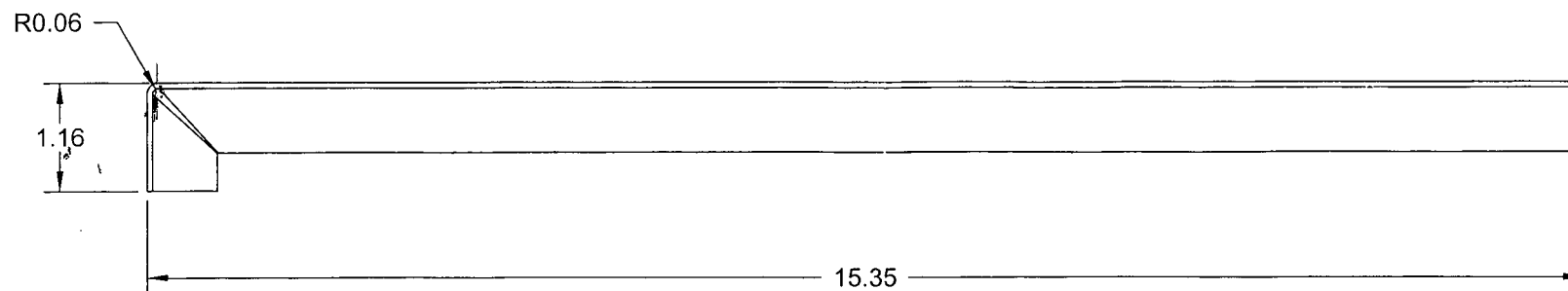
Date: 08-Oct-30

Product Name: Full vert ref door

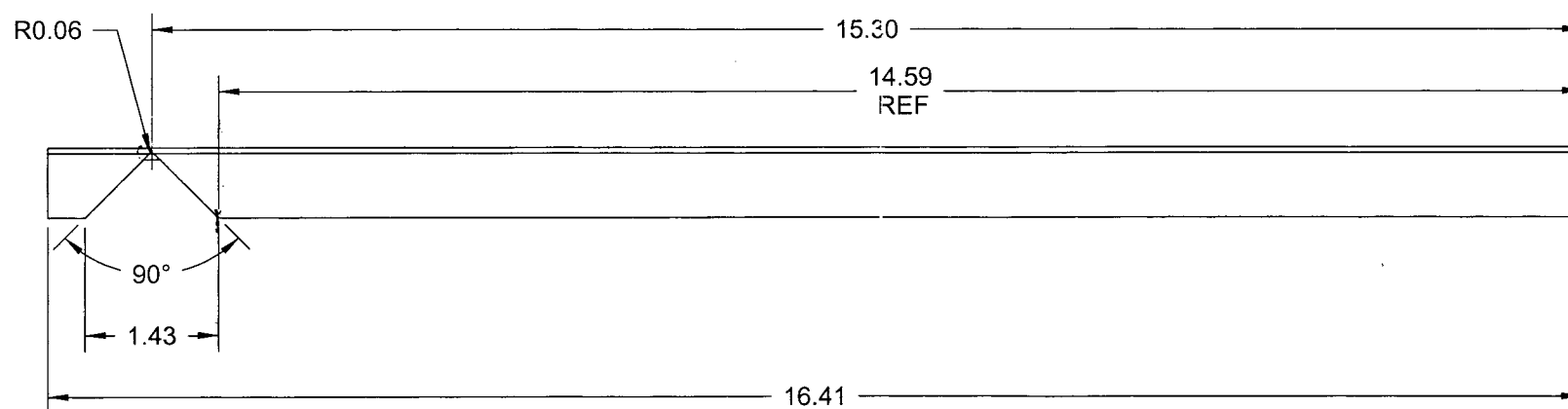
Requested By: MP

Design Manager Approval: MB

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
3	SEE ATTACHED	SMALL FAB	SEE ATTACHED LIST	10/31/08	N		Parts for training purposes	
3	D3701-1 *	05061						
3	D3703-1	05062						
3	D3708-1	05063						
3	D3708-3							
3	D3709-1							
3	D3709-3							



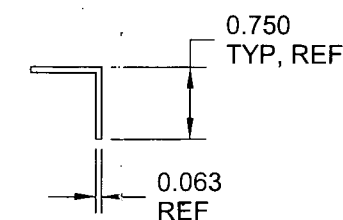
D3708-1 ANGLE
(MAKE FROM D3708-1F)



D3708-1F FLAT PATTERN

**PRELIMINARY
ISSUE**
08/10/31 MD

~~PROTOTYPE~~



DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3708	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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D3708-1 ANGLE



D3708-3 ANGLE

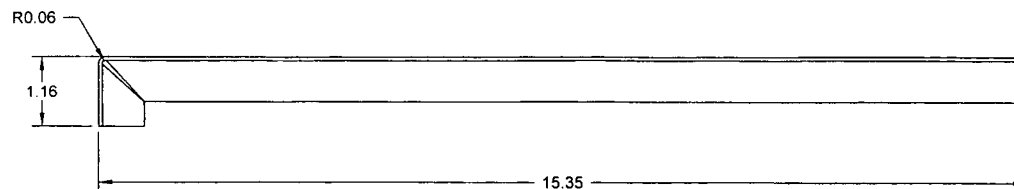
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.063
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3708-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3708-1 = 0.16 lbs
D3708-3 = 0.14 lbs
- 8) CONTROL SHAPE PER DT9019 TEMPLATE

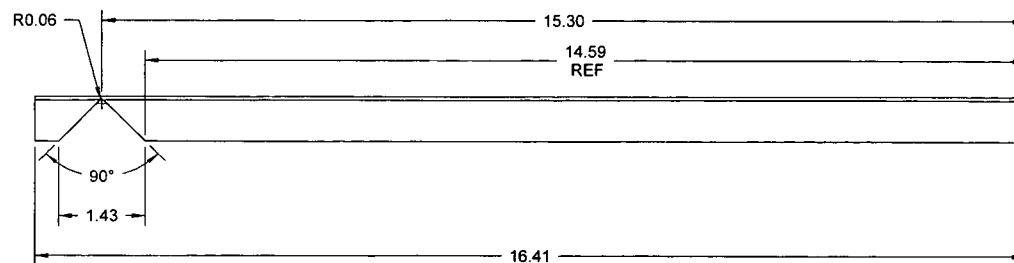
WLO 05063

RELEASED
09/04/08 NP

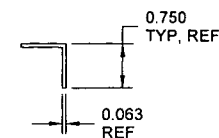
A	NEW ISSUE		MB	08.02.14
REV.	DESCRIPTION		BY	DATE
DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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D3708-1 ANGLE
(MAKE FROM D3708-1F)



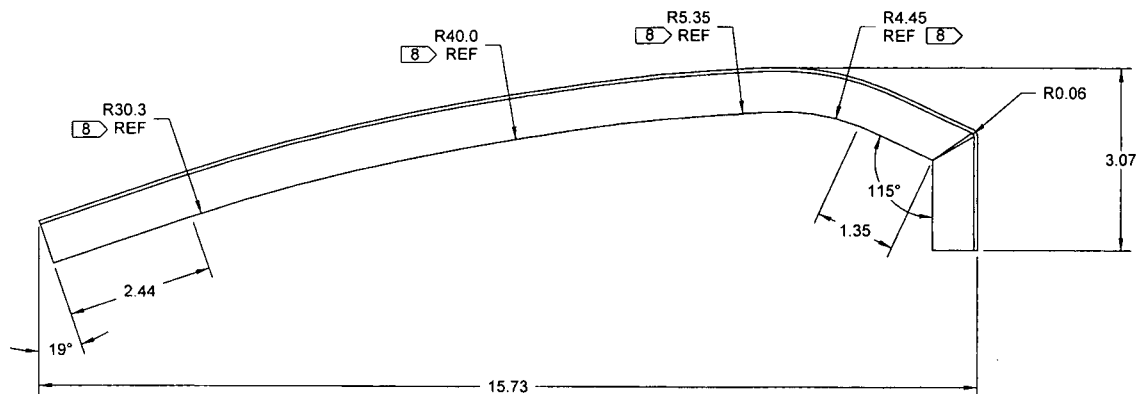
D3708-1F FLAT PATTERN



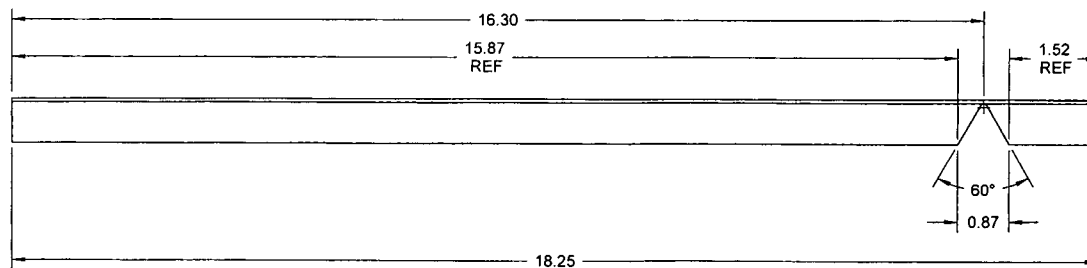
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D3708-3 ANGLE
(MAKE FROM D3708-3F)



D3708-3F FLAT PATTERN ANGLE

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09/04/09

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